Work Drder						+			_		
	r ID 60763 , 2010 10:52:24 AM										Page
Revision ID:	D3575-6 Cabin Floor Protector		Accept					Setup			
Start Date: 7/2 Required Date: 7/2 Reference:	/22/2010 Start Qty: 3.0 /29/2010 Req'd Qty: 3.0			Cust I Custor	tem ID: ner:				Stop		
	Process Plan:	Date:/b-7-2/	Tooling:		Date:			Run	Start		
	QC:	Date:	SPC (Y/N):		Date:		-		Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool	ID Tool	# Plan	Accept			Reject	Insp.
Draw Nbr	Revision Nbr		110413			Code	Qty	Qty	<u>N</u>	Number	Stamp
D3575	Rev A						,				
100 	FLOW WATER JE	Γ	0.00								
Waterjet	Memo		0.00					10-7	- 22	·	
LOW CNC Waterjet	l-Cut a Deburr	s per Dwg D3575 Dwg Rev:	A □Prog Rev: Δ	□2-		15) 17) 18)					B
	QC2- Inspect parts of	off machine FAI/FAIB	0.00	1		2-					
QC Quality Control	Мето		0.00	:		-	1 <u>P</u>	3 (0-	<u>1-5</u>	2	
	•				•						
20 	QC8- Inspect parts -	second check	0.00								
QC uality Control	Memo		0.00 2,0(0	7/26		r	43)			

Dart Aerospace Ltd	Dart	Aer	OS	oace	Ltd
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W/O:			V	ORK ORDER CHAN	GES					٠,
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	aty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								-		
Part No	:	PAR #:	Fault Ca	tegory:	NCF	R: Yes I	lo DQA:		_ Date: _	·····
	R	esolution:	Disposit	ion:	QA:	N/C Clo	sed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	IANCE	(NCR)				
DATE	STEP	Description of NC	Initial	Corrective Action Se Action Description	ection B	Sign &	Verifica	ication Approval		Approval
		Section A	Chief Eng	Chief Eng	_	Date	Section	C	Chief Eng	QC Inspector
3					•					
		,								
-		·								
	1									

Work Ord Thursday, July 2	er ID 60 22, 2010 10:	0763 52:24 AM					; 9 6			 -		Page 2
Item ID: Revision ID: Item Name:	D3575-6 Cabin Floor F	Protector		Accept		<u>.</u> 			Setup	Start		
Start Date: Required Date: Reference:	7/22/2010 7/29/2010	Start Qty: 3.00 Req'd Qty: 3.00			Cust I Custo	tem ID: -	,			Stop		
Approvals:	Process Pla	ın:	Date:			Date:			Run	Start Stop		
Sequence ID/ Work Center ID		Operation Description Small Fab		Set Up/ Run Hours	Tool		Plan Code	Accep Qty	t Rejo		eject i	insp.
Small Fab		Memo Deburr if neces	ssary.	0.00				L	50)	07	126	(3)
QC Quality Control		QC5- Inspect part complete Memo	ness to step on W/O	1000 2 00.00 C 00.00	176			- (3)				
150 Packaging Packaging		ldentify as per dwg & Stock Memo	Location:	• 0.00 W	20760) 1-	ľ	ン ・フ	37	sp	

Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Cty Chief Eng / Prod Mgr OC Inspector Approval Chief Eng / Prod Mgr OC Inspector

Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	 Date: _	
	Resolution:		Disposition:	QA: N/C Closed	i:	Date: _	

NCR:	:	,	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	NC Corrective Action Section B Verifica				Approval	Approval			
DATE	STEP	Section A			Sign & Date	Section C	Chief Eng	QC Inspector			
			1								
		.									
	1										

Work Order ID 60763 Thursday, July 22, 2010 10:52:24 AM Item ID: D3575-6 **Revision ID:** Item Name: Cabin Floor Protector **Start Date:** 7/22/2010 Start Qty: 3.00 Required Date: 7/29/2010 Req'd Qty: 3.00

QC:





Setup, Start

Stop



Page 3

Cust Item ID:

Date:

Date:

Customer:

Tool ID

Run Start Stop

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Sequence ID/

Reference:

Approvals:

Work Center ID 160

Quality Control

Memo

Operation

Description

Process Plan: _____ Date: ____ Tooling:

QC21- Final Inspection - Work Order Release

Date:

0.00

0.00

SPC (Y/N):

Set Up/

Run Hours

Accept

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES					ţŗ.
DATE	STEP	PRO	CEDURE CH	ANGE	B	,	Date	фtу	Approval Chief Eng /	Approval QC Inspector
									Prod Mgr	
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. ,			-							
										-
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Y	'es N	lo DQA	_	Date: _	
	R	esolution:	Dispositi	on:	_ QA: N/	C Clo	sed:	 	Date: _	
NCR:		1	WORK ORE	DER NON-CONFORMA	ANCE (N	ICR)			-	
DATE	CTED	Description of NC		Corrective Action Section		gn &	Verifica	ion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng				Section	С	Chief Eng	QC Inspector
						•			<u> </u>	
		·								
						A.41.0				
	,									

Status

Required Date: 7/29/2010

Date

Issued

Required Qty: 3.00

Qty

Issued

Picklist Print

Thursday, July 22, 2010 10:52:28 AM

Work Order ID: 60763

Parent Item: D3575-6

Parent Item Name: Cabin Floor Protector



Last

Location

Route

Seq ID

100

Unit of

sf ·

Measure Hand

Comments:

IPP Rev :A New Issue 07.07.23

Replacement Mfg/

verified by:JLM

Primary

Bin

Item Name Item ID Purch Item Location MLEXS.125-F60029-04 Purchased No

GE PLASTICS LEXAN SHEET

Component Item ID/

				PB10-7-22
Location	Loc Oty	Loc Code		
MAT	3321.7068	<u> 200 Code</u>		1
111710	10		F	
112585	155.783			(3)
114032	467.9238			
115261	2688		116-761	

Qty on

3,321.706

Start Date: 7/22/2010

Qty per Kit Total

Qty

115261

33.68211

Start Qty: 3.00

10.666

Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANG	ES		1		· · · ·
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	oty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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					-				
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA :		Date:	•
	R	esolution:	Disposition	າ:	QA: N/C C	osed:		Date: _	
NCR:		V	WORK ORDI	ER NON-CONFORM	ANCE (NCF	?)			
DATE	STEP	Description of NC	· · · · · · · · · · · · · · · · · · ·		ion B	Verifica	tion	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector
									5
	1								

DART AEROSPACE LTD	Work Order:	11173
Description: Cabin Floor Protector		_ <i>UU,U,U</i>
- Totectol	Part Number:	D3575-6
Inspection Dwg: D3575 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

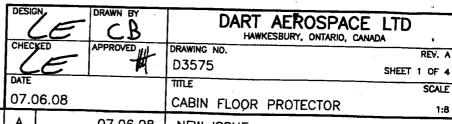
X First Article Prototype

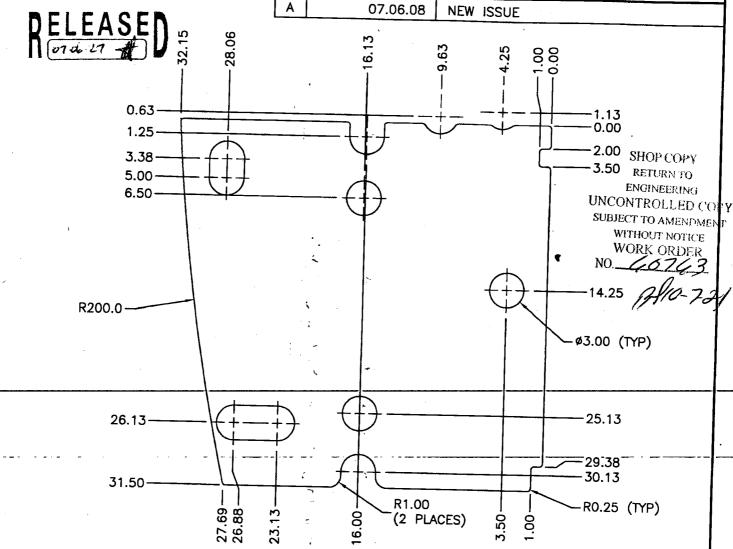
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	
Ø3.00	+0.006/-0.001	3,003	X			
3.38	+/-0.030	3.38	8		1202	
6.50	+/-0.030	6,86	8		TBOL	-
26.13	+/-0.030	26.13	\		7	
30.13	+/-0.030	30,13	*		T	
2.00	+/-0.030	2.00	8		7	
3.50	+/-0.030	3.50	K		7	
14.25	+/-0.030	14.26	3		-	
25.13	+/-0.030	25.13	*		7	
29.38	+/-0.030	29.38	ds.		7	
30.38	+/-0.030	30.38	80		_ <u>\</u>	
31.50	+/-0.030	31.50	8		7	
1.00	+/-0:030	1.06	a		<u> </u>	
4.38	+/-0.030	1, 70	4		T	
14.50	+/-0.030		4		7 •	
16:00	- +/-0:030		0		7	
23.13	+/-0.030	_	B		†	
26.88	+/-0.030	المسام	8		7	
27.69	+/-0.030		<i>x</i>			
1.00	+/-0.030	1.00	A			
3.75	+/-0.030		82		T	
9.63	+/-0.030	2 (2	*			
16.13	+/-0.030	<i>(</i>)	*		7	
28.06	+/-0.030	. 0 (>		7	
32.15	+/-0.030	33.15	<u> </u>		7	

Measured by: Audited by: Prototype Approval: N/A 10-7-27 Date: Date: colostac Date: N/A Rev Date Change Revised by, Approved 08.01.16 New Issue KJ//DD

Dart Ae	rospac	e Ltd									
W/O:				W	ORK ORDER C	HANGES					
DATE	STEP	E.	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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Part No);		PAR #:	Fault Cat	egory:	NC	R: Yes	No DQ	A:	Date: _	
	R	Resoluti	ion:	Dispositi	on:	Q <i>A</i>	A: N/C CI	osed:	• •	Date: _	
NCR:				WORK ORE	ER NON-CON	FORMANC	E (NCF	R)			
			Description of NC		Corrective Action	Section B		Verifi	cation	Approval	Approva
DATE	STEP		Section A	Initial Chief Eng	Action Desc Chief En		Sign 8 Date	k Sect	ion C	Chief Eng	QC Inspect
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D3575-1 CABIN FLOOR PROTECTOR (SHOWN) D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

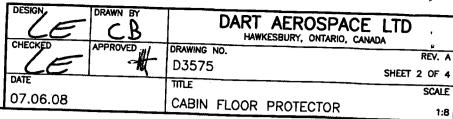
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- -2) -FINISH: NONE -
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

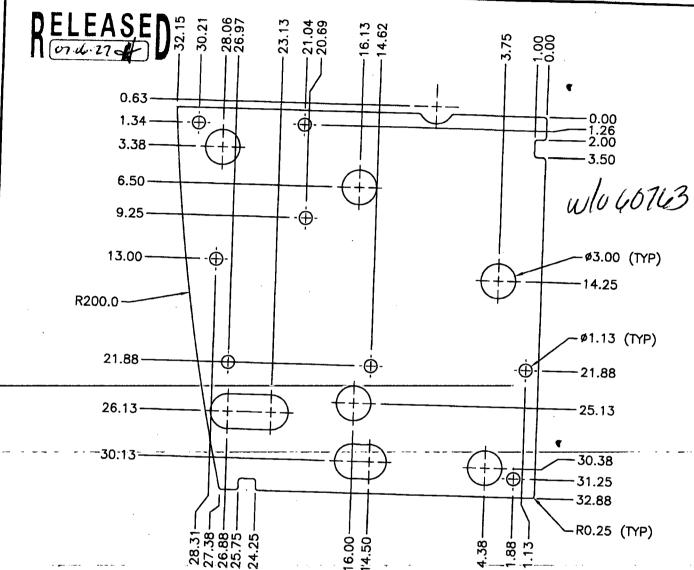
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Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval **Approval** DATE **STEP PROCEDURE CHANGE** By Date Qty Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: _____ Fault Category: ______ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____ **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B Description of NC Verification **Approval Approval** DATE STEP Sign & Initial **Action Description** Section A QC Inspector Section C Chief Eng Date Chief Eng Chief Eng







D3575-3 CABIN FLOOR PROTECTOR

NOTES:

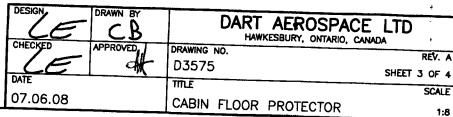
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

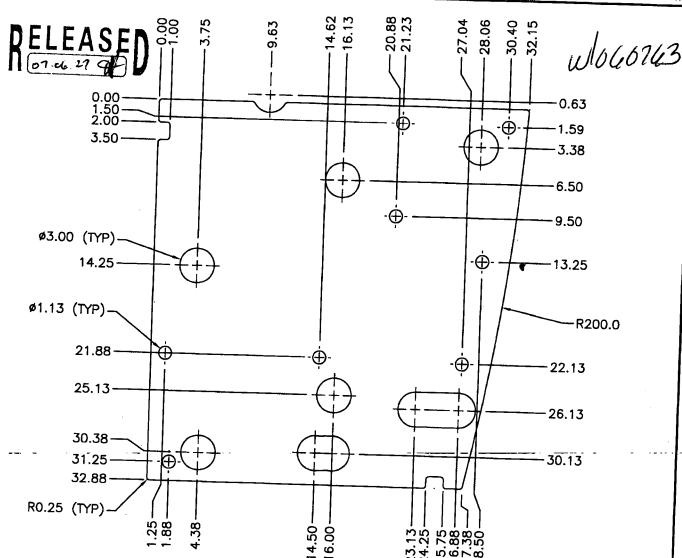
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Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval Approval** PROCEDURE CHANGE Ву Qty DATE **STEP** Date Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: _____ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Verification Description of NC **Approval Approval STEP** DATE Sign & **Action Description** Initial Section A Section C Chief Eng QC Inspector **Date** Chief Eng Chief Eng







D3575-4 CABIN FLOOR PROTECTOR

NOTES:

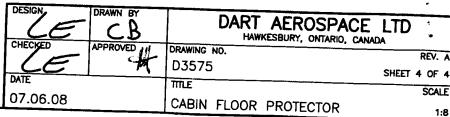
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2)-FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

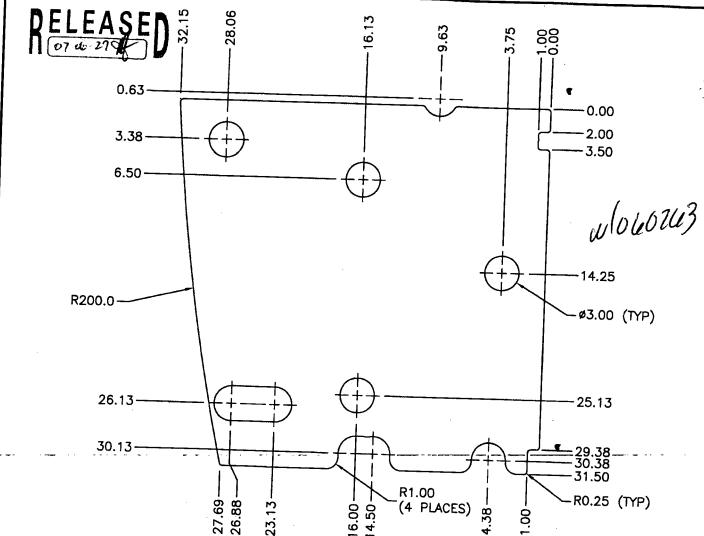
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Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval Approval** DATE **STEP** PROCEDURE CHANGE By Qty **Date** Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: _____ Fault Category: ______ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Verification Description of NC **Approval** Approval **STEP** DATE Sign & Initial **Action Description** Section A Section C Chief Eng QC Inspector Chief Eng Date Chief Eng







D3575-5 CABIN FLOOR PROTECTOR (SHOWN) D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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Dart Aerospace Ltd W/O: **WORK ORDER CHANGES Approval Approval** DATE **STEP** Qtv By PROCEDURE CHANGE **Date** Chief Eng / QC Inspector Prod Mar Part No: _ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____ **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE **STEP Action Description** Sign & Initial Section A Section C Chief Eng QC Inspector Date Chief Eng Chief Eng